

Date: Thursday, 12/14/2006 3:46:49 PM
 User: Kim Johnston

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|-------------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 3"SKIDTUBE LIGHT "I" BEAM EXTRUSION |
| Job Number : | 29985 | | |
| Estimate Number : | 10306 | | |
| P.O. Number : | N/A | Part Number : | D26005108 |
| This Issue : | 12/14/2006 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D2600 REV D1 |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | 24410 | Drawing Revision : | D1 |
| | | Material : | N/A |
| Written By : | | Due Date : | 1/15/2007 |
| Checked & Approved By : | | Qty: | 115 |
| Comment : | Est F 02/09/10 Added DSK 066 KJ/RF | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

1.0

PG

PURCHASING



Comment: Issue P/O: 2722

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 108" long
- g) Caradon Indalex Tool # MS-18871
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C 206112115

115

2.0

D26005108P

Extrusion 'I' Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 115.0000 Each(s)

EXTRUSION "I" BEAM THIN

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Receive & Inspect For Transit Damage
 Ensure certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

- 1-Inspect dimensions per Dwg D2600
- 2-Check Pull test per Dwg D2600 for compliance page attached.
- 3-Check hardness with Webster tester

280
 107/12/28 (15)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FP Date: 07/03/05

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:46:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3"SKIDTUBE LIGHT "I" BEAM EXTRUSION

Job Number: 29985

Part Number: D26005108

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *in the shop*

JD 7-2-1

(280)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(280)

Comment: FINAL INSPECTION/W/O RELEASE

207/03/05

Job Completion



CU 8/03/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 1 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |
| A | 97.01.21 | NEW ISSUE | |
| B | 97.09.09 | CHANGE MATERIAL SPEC. | |
| C | 98.04.16 | ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO. | |
| D | 98.08.20 | INCREASE MIN. UTS TO 40 KSI | |
| DI | 01.04.17 | ADD PART NUMBERS & DIE NUMBERS <i>+GP</i> | |

RELEASED
48.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

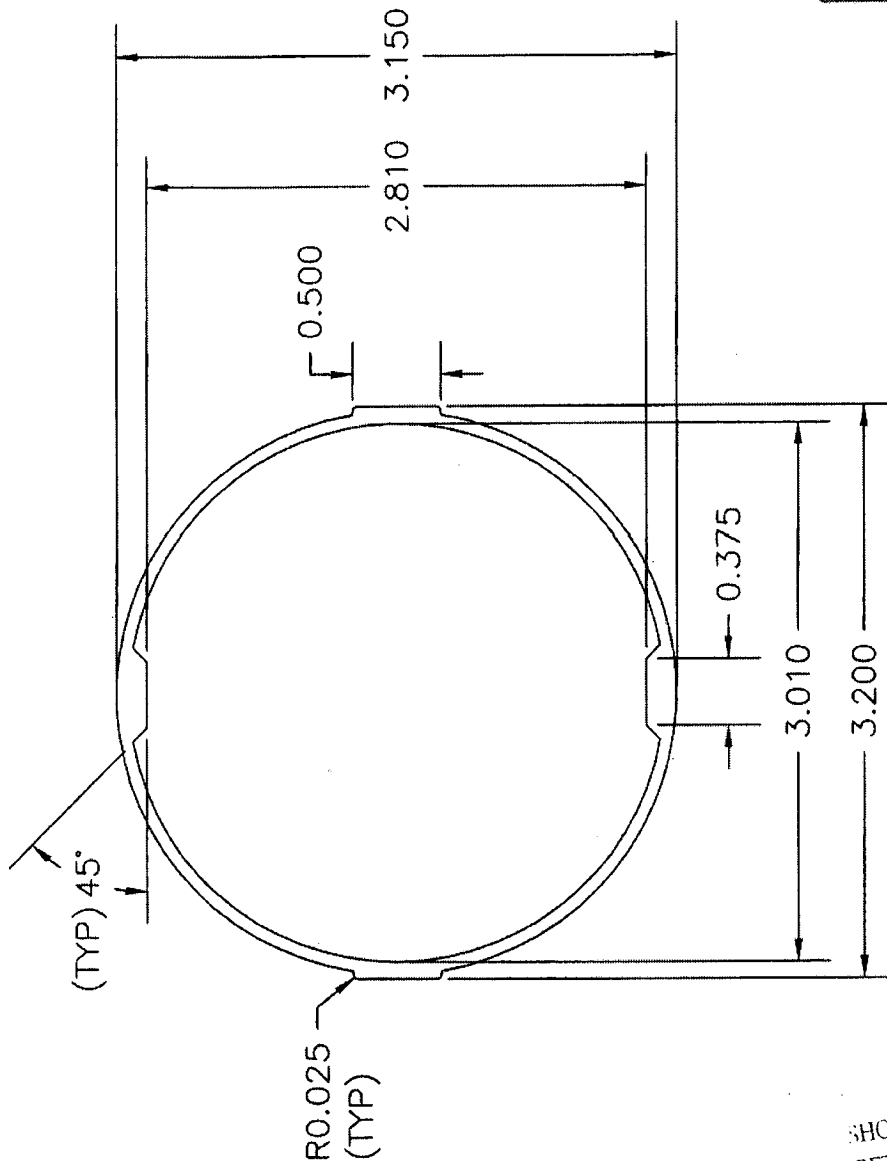
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29985



| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>WJ</i> | DRAWN BY <i>WJ</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>WJ</i> | DRAWING NO. D2600 | REV. D SHEET 2 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

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98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

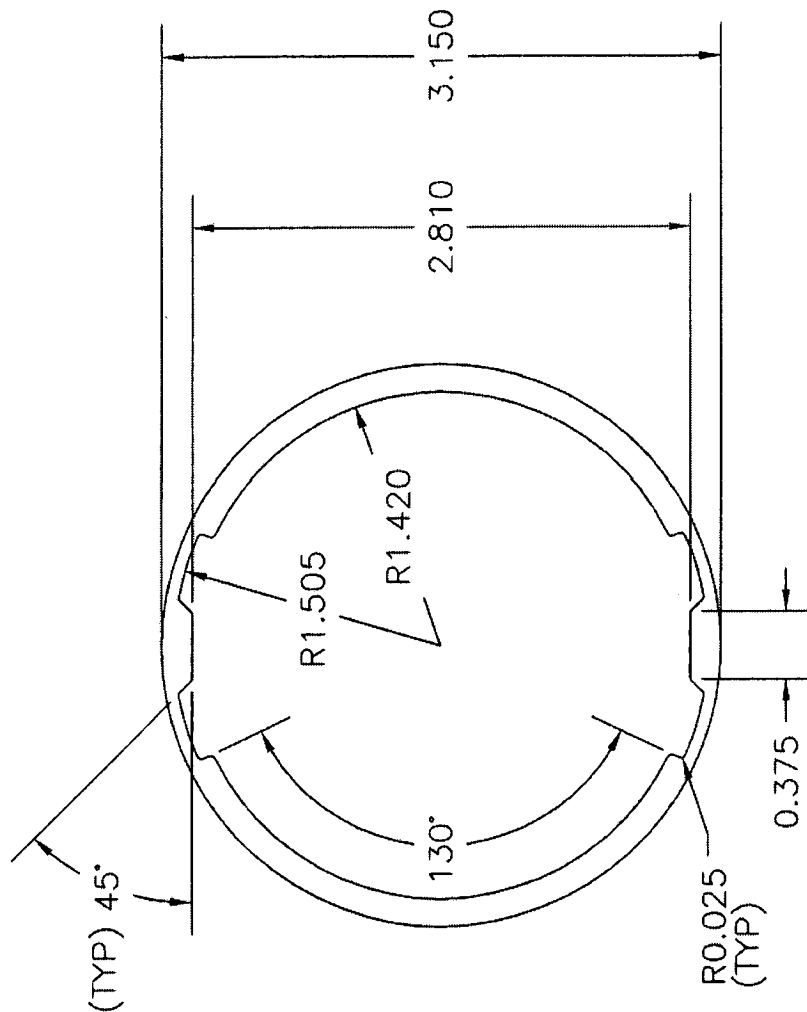
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WORK ORDER
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| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 3 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

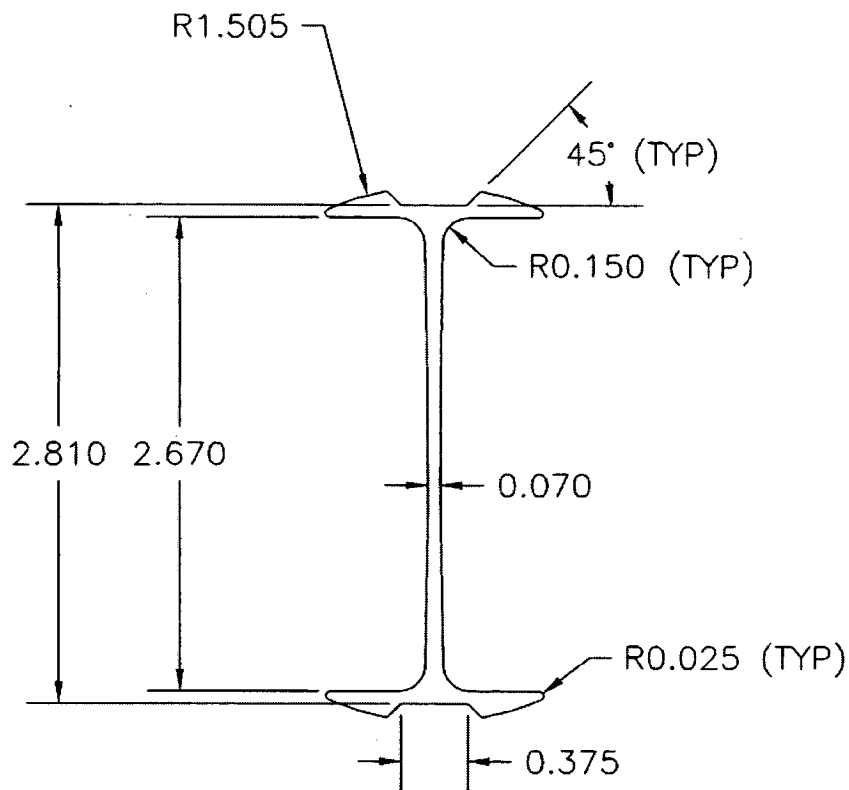
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| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. D |
| KE | ✓ | D2600 | SHEET 4 OF 5 |
| DATE | TITLE | EXTRUSION | SCALE |
| 98.08.20 | | | 1:1 |

RELEASED
98.8.25. bs



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

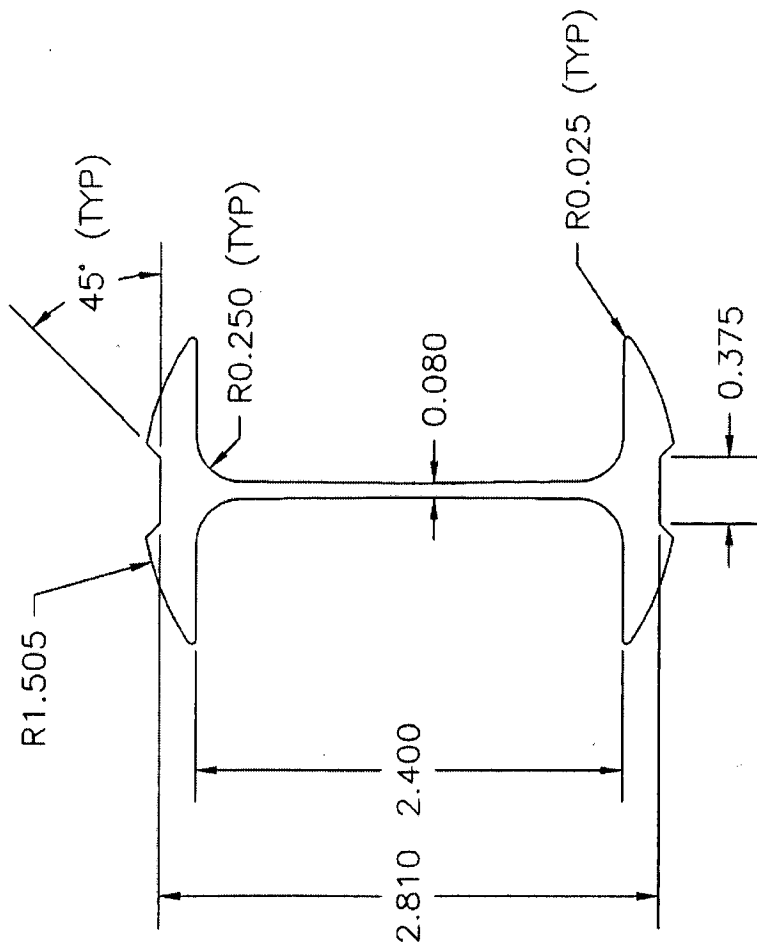


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| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>RE</i> | DRAWN BY <i>RE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>RE</i> | APPROVED <i>RE</i> | DRAWING NO. D2600 | REV. D SHEET 5 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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NO. 29985





PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE
ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

P/S#: 584420

THE JOURNAL OF
SOCIETY

6122003

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS

MÊME - SAME

K6A1K7

CUSTOMER P.S.T. : *6122-5207

INDALEX G.S.T. REG NO: R136834041

Required Date:

| | | | | | | | | |
|---------------------------|---------------------------|--|--|--------------------------------|---------------------------------------|---------------------------------|----------------------|--|
| N° DU CLIENT CUST. NO. | T.P.S. G.S.T. | TAXE DE VENTE PROV. PROV. SALES TAX | N° DE COMM. DU CLIENT CUST. ORDER NO. | DATE DE COMMANDE ORDER DATE | NOTRE DATE DE COMM. OUR ORDER DATE | CONDITIONS TERMS | | |
| 201355 | XXXXXX | | 2722 | 6/12/18 | 6/12/19 | | | |
| VENDEUR. SALESMAN | EXPÉDIÉ PAR SHIP VIA | PAYÉ P.P.T. | PERC. COL | C.A.D. C.O.D. | F.A.B. F.O.B. | EN BALLOTS BUNDLED AND TAPED | CARTONNÉ CARTONED | CARTONNÉ & INTERCALÉ CARTONED & INTERLEAVED |
| 51 | NOTRE CAMION OUR TRUCK | X | | | NOTRE USINE OUR PLANT | | | |

[illegible]

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures

ISO

9001

FORM 118XF / REV. 09/00 H+H

EXEMPLAIRE DE LA COMPTABILITÉ
ACCOUNTING COPY

FEUILLE D'EMPAQUETAGE
PACKING SLIP



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fax-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**
Adresse / Address : **1270 ABERDEEN STREET**
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : **6122003**
bon de commande / Purchase order # : **2722**
de matrice / Die # : **MS 18871** Description : **D-2600-5 Light Duty Web**
Alliage & trempage / Alloy & temper : **6061 T6**
Contrôle / Control # : **36071-1**
Coulée / Cast # : **39544**

| | Min.requis Min.required | Résultat actuel Actual results |
|--|----------------------------|-----------------------------------|
| Tension ultime Ultimate stress (psi) | 38 000 | 47859 |
| Contrainte élastique Yield stress (psi) | 35 000 | 43224 |
| % élongation dans 2" % elongation in 2" | 8 | 12.5 |
| Dureté Rockwell E (hre) Rockwell E Hardness (hre) | 88 @ 100 | 96 |

Composition chimique typique / Typical chemical composition :

| | Si | Fe | Cu | Mn | Mg | Cr | Zn | Ti |
|-------|-------------|-------------|-------------|-------------|-------------|-------------|----------|----------|
| 6063 | 0.20 - 0.60 | 0.35 Max | 0.10 Max | 0.10 Max | 0.45 - 0.90 | 0.10 Max | 0.10 Max | 0.10 Max |
| 6005 | 0.60 - 0.90 | 0.35 Max | 0.10 Max | 0.10 Max | 0.40 - 0.60 | 0.10 Max | 0.10 Max | 0.10 Max |
| 6005A | 0.68 - 0.72 | 0.15 - 0.27 | 0.08 - 0.12 | 0.20 - 0.24 | 0.48 - 0.52 | 0.03 Max | 0.05 Max | 0.08 Max |
| 6061 | 0.40 - 0.80 | 0.70 Max | 0.15 - 0.40 | 0.15 Max | 0.80 - 1.20 | 0.04 - 0.35 | 0.25 Max | 0.15 Max |
| 6351 | 0.7 - 1.3 | 0.5 Max | 0.10 Max | 0.40 - 0.80 | 0.40 - 0.80 | — | 0.20 Max | 0.20 Max |

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 200/8 ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 200/8 standard and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

date : 2007-01-08

Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited



INDALEX LIMITED
 525 AVRO Street
 POINTE-CLAIRE, QC H9R 5W3
 TELEPHONE: (514) 697-5120 & (800) 563-5120
 FACSIMILE: (514) 694-8310 & (800) 563-8310

FACSIMILE TRANSMITTAL SHEET

| | |
|--------------------------------|---|
| TO: Christina Young | FROM: Bruno Morency Quality Technician |
| COMPANY: DART AEROSPACE LTD | DATE: 2007/01/08 |
| FAX NUMBER: 1(613) 632-4443 | TOTAL NO. OF PAGES INCLUDING COVER: 2 |
| PHONE NUMBER: | SENDER'S REFERENCE NUMBER: |
| SUBJECT: REPORT | TIME: |

☐ URGENT ☐ FOR REVIEW ☐ PLEASE COMMENT ☐ PLEASE REPLY ☐ PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report.

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